

Diamond ABS 3500 HF

Acrylonitrile Butadiene Styrene
Network Polymers, Inc.

Message:

Diamond ABS 3500 HF is an Acrylonitrile Butadiene Styrene (ABS) product. It can be processed by injection molding and is available in North America. Characteristics include:
Flame Rated
REACH Compliant
RoHS Compliant
WEEE Compliant
High Flow

General Information			
Features	High Flow		
	Medium Impact Resistance		
Agency Ratings	EC 1907/2006 (REACH)		
	EU 2002/96/EC (WEEE)		
RoHS Compliance	RoHS Compliant		
UL File Number	E150937		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.06	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) ¹			ASTM D1238
200°C/5.0 kg	3.0	g/10 min	
230°C/3.8 kg	11	g/10 min	
Molding Shrinkage - Flow	0.40 to 0.60	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	104		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ² (Yield)	49.6	MPa	ASTM D638
Flexural Modulus - Tangent ³	2480	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	210	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
1.8 MPa, Unannealed, 3.18 mm	79.4	°C	
1.8 MPa, Annealed, 3.18 mm	96.1	°C	
Vicat Softening Temperature	103	°C	ASTM D1525 ⁴
Flammability	Nominal Value		Test Method

Flame Rating (1.50 mm)	HB	UL 94
Injection	Nominal Value	Unit
Drying Temperature	80.0 to 85.0	°C
Drying Time	2.0 to 4.0	hr
Suggested Max Moisture	0.10	%
Rear Temperature	180 to 240	°C
Middle Temperature	180 to 240	°C
Front Temperature	180 to 240	°C
Mold Temperature	40.0 to 80.0	°C
Injection Rate	Moderate-Fast	
NOTE		
1.	Procedure A	
2.	51 mm/min	
3.	1.3 mm/min	
4.	Loading 1 (10 N)	

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